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# **Abstract**

Method of electrocoating substrates (2) in a continuous installation (1) as shown in Figure 1, comprising an electrocoating tank (1.1), an overflow tank (1.2), circulating pumps (1.3) and (1.5), flood pipes (1.8), a directed tank flow (1.9) which flows in the transport direction of the substrates (2) in the area of the tank base (1.6) and opposite to the transport direction of the substrates (2) in the area of the bath surface (1.10), and a conveying device (1.11) with means of transporting, rotating, immersing and emersing the substrates (2), wherein the substrates (2) are connected as cathode or anode and supplied with the aid of the conveying device (1.11) over the overflow tank (1.2) to the emersing area (1.12) of the electrocoating tank (1.1), on immersion in the electrocoating tank (1.1) are rotated at an angle of  $> 100^\circ$  to the original position, are transported through the electrocoating tank (1.1) and coated, on emersion are rotated back into the original position, and thereafter are passed on for further processing.